

Work Order ID 85457

June-08-12 10:01:58 AM

85457

Page 1

Item ID: D3537-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearpad

Start Date: 08/06/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/08

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3537	Rev C								
100		0.00							
100	FLOW WATER JET								
Waterjet		0.00				<u>50</u>	<u>0</u>		<u>Jm</u>
FLOW CNC Waterjet	Memo								<u>12-6-9</u>
304 .063	1-Cut as per Dwg D3537Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-Deburr if necessary								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC		0.00				<u>50</u>	<u>0</u>		<u>Jm</u>
Quality Control	Memo								<u>12-6-9</u>
120		0.00							
120	QC8- Inspect parts - second check								
QC		0.00							
Quality Control	Memo								

located
(Y)O

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

NC BRAKE

0.00

0.00

Memo

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.2-
Identify as D3537-1

49

12/06/13

140

140

Large Fab

Large Fab

0.00

0.00

Memo

Qty Description Batch A/R 2059B Hardcoat
M122030 1-Weld as per Dwg D3537 using Jig DT 82102-Remove any
weld that penetrated through Wearpad if necessary

49

12-06-26

150

150

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

0.00

Memo

8/2/06/27

counts
49

NCR: ☒ Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DOA: 12/01/04 Date: 12/01/04QA Closed: 12/21/05 Date: 12/21/05

Work Order: <u>85457</u> Part No. <u>D3537-1</u> NCR No. <u>12-1588</u>				DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Prod. Eng. Coord. <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input checked="" type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Other <input checked="" type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input checked="" type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input checked="" type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>																								
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Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>																									
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input checked="" type="checkbox"/>																									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector																		
Doc/Data	12/04/13	#100	(21)	Part found with a notch on top of hole. Re. Parts were cut too close together: water jet operator	12/04/13	Scrap Duty no Reuse \$21.94	12/04/13	12/04/13	12/04/13																		
Equip/Tooling																											
Operator																											
Material																											
Offset/Setup																											
Other																											
Process																											
Supplier																											
Training																											
Unauthorized																											

FAULT CATEGORY

Landing Gear

Hardware

General

- ☐
- Bending Passes Below Min
-
- ☐
- Centre Not Concentric to O/S
-
- ☐
- Cracks
-
- ☐
- Crushed/Crimp at Bending
-
- ☐
- Inspection Strip in Tube
-
- ☐
- Other
-
- ☐
- Positioned Wrong
-
- ☐
- Ripples on Inner Bend
-
- ☐
- Torque Waves in Extrusion
-
- ☐
- Turning Sequence
-
- ☐
- Wave/Twist in Tube

- ☐
- Breaking
-
- ☐
- Missing
-
- ☐
- Size/Length
-
- ☐
- Spinning
-
- ☐
- Threading
-
- ☐
- Wrong

Drill Holes

- ☐
- Misaligned
-
- ☐
- Ovalized
-
- ☐
- Over/Undersized
-
- ☐
- Too Many

- ☐
- Burrs
-
- ☐
- Contamination
-
- ☐
- Cut Too Short
-
- ☐
- Documentation/Data
-
- ☐
- Finish
-
- ☐
- Inspection Incomplete
-
- ☐
- Inspection Unqualified
-
- ☐
- Instructions Incomplete/Unclear
-
- ☐
- Jigs/Fixtures/Tooling
-
- ☐
- Kit Incorrect
-
- ☐
- Kit Missing

- ☐
- Maintenance
-
- ☐
- Mislabeled
-
- ☐
- Off-Set
-
- ☐
- Orientation Misread
-
- ☐
- Out of Calibration
-
- ☐
- Out of Sequence
-
- ☐
- Outside Dimensions
-
- ☐
- Over/Under tolerance
-
- ☐
- Part Lost
-
- ☒
- Part Moved
-
- ☐
- Raw Material

- ☐
- Set-up
-
- ☐
- Supplier
-
- ☐
- Temperature/Cure
-
- ☐
- Weld
-
- ☐
- Wrong Stock Pulled
-
- ☐
- Other

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Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

170

Powdercoat

Memo

0.00

Powder Coating

START TIME:

7h25

OVEN TEMPERATURE:

320°F FINISH TIME:

7h55

m121279.

49

8

2P

12/06/28.

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

49

6

12/26-28.

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Revision ID:

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Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 50.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>FP-1</u>	0.00							
190									
Packaging	Memo	0.00				x49	6	11	11/06/28
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

12/0/28
ME
12-06-28

Picklist Print

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Page 1

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85457

Parent Item: D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	122.6624	0.106	5.578947			

M304S16GA

**

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

122.662433

121626

21.4778

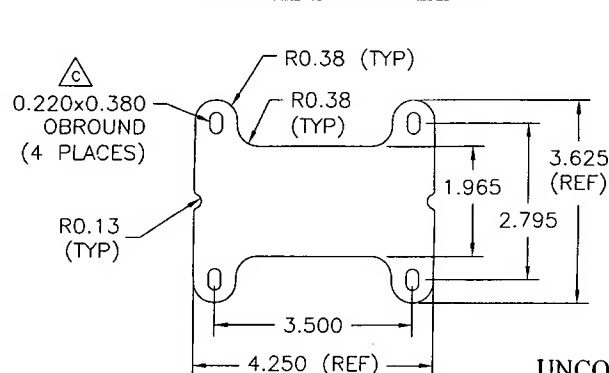
121889

101.184633

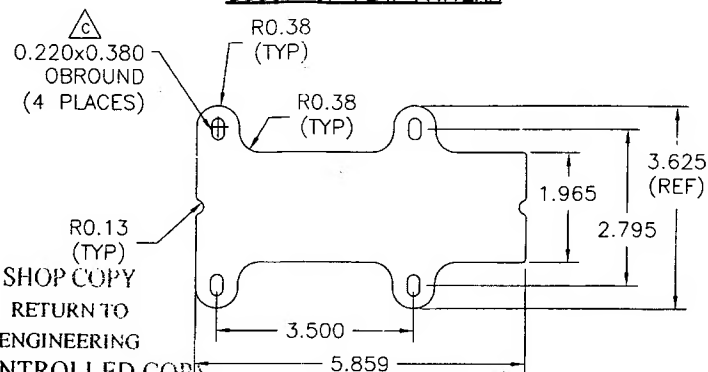
121626

JM
12-6-9

D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

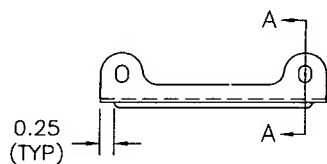


UNCONTROLLED COPY
SUBJECT TO AMENDMENT

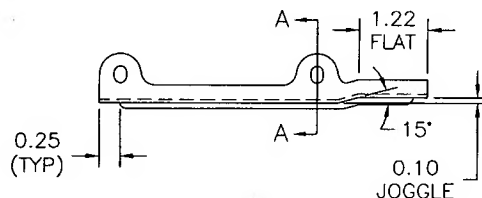
WITHOUT NOTICE
WORK ORDER

NO. 05457 MLJ 12/06/08

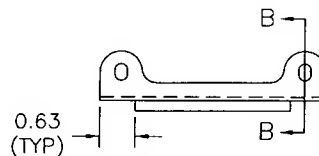
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



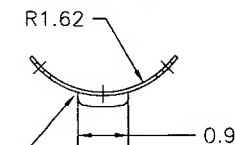
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

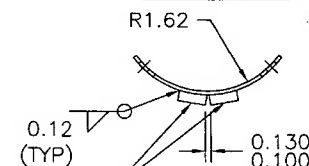
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

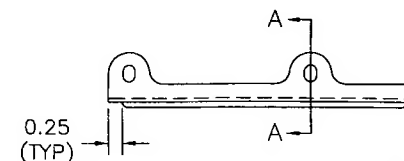
SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07.05.08 PM
per ECN 962

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	4	APPROVED 4
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
		SHEET 1 OF 1
		SCALE 1:2

DART AEROSPACE USA, INC.
PORT HADLOCK, MA